Per												
Work Orde November-12-13				*109165*								Page 1
Revision ID:	D2933-1 206 Saddle L	eft		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	11/12/13 11/26/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer:	ID:			D	Stant		
Approvals:	Process Pl	an: MLS	Date: <u> </u>		Date: Date:				Run	Stop	.*N N*	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr D2933		vision Nbr									,	
*100 *100* HAAS 1 HAAS CNC vertical	machine #1	number ar inspect as	AL MACHINING #1 part number and batch number programmed correctly.2-M per dwg D2933 & attached Ind visually inspect as per	achine Step No 1 of Foli	io and visually		D4 0 2	s) ET		3-1	1-28	, (x4)
*110 * Mill Conv Conventional Millin	g Machine	CONVENTIONAL M Memo Machine	ILLING MACHINE Keyway and inspect per attacl	0.00 0.00 ned dimension sheet			DAG	25	12	> - \(- 24	's (x4

0.00

0.00

3 - 11 - 26 (x4)

120

120

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

DQA:			Date:			— DART								
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE	W	ork Order up	date only	7	AEROSPACE
		**				DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS		
Work Orde	er: _									_	1	_	7	
Part N	lo.					Rework Scrap			Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	lo					Use-as-is		mern	Large Fab Composite	-	Nec/3tol	Supplier		Other
Root					Desci	ription of work order update		nitial	Action		Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre					t									
Material						·								
Operator			•	İ										
Offset/Setup		5												
Process		:			,									
Supplier													l	
Training						•	1						1	
Transport													ı	
Unapproved			l				l							
		<u> </u>					FA	ULT CA	TEGORY					
Landi	ng (Gear				General		····						
		Bending				Bend		Folio/I	Program	Г	Outside Dim	ensions	F	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ાં _	_]1	Temperature/Cure
					Burrs		Inspect	tion Incomplete/Unqualified	Г	Part Lost/Mi	ssing	\	Weld	
					Contamination		Instruc	tions Incomplete/Unclear		Part Moved		\neg	Wrong Stock Pulled	
	Crushing Countersink				Countersink	Misaligned/off center Positioned Wrong								
		Heat Trea	at			Cut Too Short		Mislab	-		Power Loss/	Surge	\Box	Other
				Drawing		Misrea			-	_				
					Drill Holes		Off-set	•			****			
	Turning Sequence Finish					=	Г	-	Calibration					
-						Fit/Function		Out of	Sequence					

109165

Page 2

3 3:19:31 PN	1								•	
D2933-1 206 Saddle Le	eft		Accept	*N900	040	100)* s		14.	S1* S2*
11/12/13 :: 11/26/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item 11 Customer:	D:				ı	. 12
						·	R		1/1	R1* R2*
ID .	Operation Description	and about	Set Up/ Run Hours	Tool ID		Code	Accept Qty			Insp. Stamp
	QC8- Inspect parts - sec	ond check	0.00	M_131	/11/29		4	<i>9</i>		
	Chemical Conversion Co	oat per QSI005 4.1	0.00				<i>د</i> ر	$\neg \mathbb{Z}$	13_1	2.2
	Memo		0.00				7	149_	75 (
	M 126 B Memo	9 9	0.00 0.00 _overtemperature:				4 4	6_1347	7-2.	Das 34 989
	D2933-1 206 Saddle L 11/12/13 :: 11/26/13 Process Pla	D2933-1 206 Saddle Left 11/12/13 Start Qty: 4.00 2: 11/26/13 Req'd Qty: 4.00 Process Plan: QC: Operation QC8- Inspect parts - second Memo Chemical Conversion C	D2933-1 206 Saddle Left 11/12/13	D2933-1	D2933-1	D2933-1	D2933-1	D2933-1	D2933-1	D2933-1

DQA:			Date:												
					WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	ır.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
VVOIR OIG	•					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering		
Part N	lo.					Scrap	il		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•				_	Use-as-is			moforming	Finishing	-	re/Packaging	Other		
NCR N	lo.					Suspected Unapproved			Large Fab						
	•			*			•				_				
Root					Desc	ription of work order update		nitial	Actio	n	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector		
Design											ļ				
Doc/Data	_						1								
Equip/Tooling												<u>.</u>			
Handling/Pre	_		!								,	<u> </u>			
Material									<u> </u>						
Operator	_												·		
Offset/Setup															
Process															
Supplier															
Training Transport															
Unapproved						•									
Oliappioved		<u> </u>	L				FΔ	ULT CA	TEGORY						
Landi	ng (Gear				General	•••			· · · · · · · · · · · · · · · · · · ·					
		Bending				Bend	Г] Folio/F	Program	Γ	Outside Dim	ensions [Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain			Over/Under	 	Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	-	Temperature/Cure		
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Weld		
	_	Cuffs				Contamination	Г	1 .	tions Incomplete/Un	 	Part Moved		Wrong Stock Pulled		
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	-		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other		
		Inspectio	n Strip in	Tube		Drawing		Misrea	d						
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe .		Fit/Function									

Work Ord November-12-13				*10	916	5*							Page 3
Item ID: Revision ID: Item Name:	D2933-1 206 Saddle L	.eft		Accept	*N	1900	<u>040</u>	100)* 5	Setup	Start Stop	14.	S1* S2*
Start Date: Required Date: Reference:	11/12/13 11/26/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust Item l Customer:	ID:						
Approvals:		an:	Date:	Tooling: SPC (Y/N):			ate:	**************************************	1	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00		Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto	ck Location	0.00					4 x			F). 3-12-3
180		QC21- Final Inspection -	Work Order Release	0.00							. 1)	, 1

0.00

Memo

180

Quality Control

13/12/4 All N13-12-4

DQA:			Date:				ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RIMANCE / UF		ork Order up	odate only	AEROSPĀCĒ	
•						DISPOSITION					EPARTMENT			
Work Orde	er: _			_							<i>-</i>	_		
						Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part N	No					Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality	
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	۱o. <u>-</u>					Suspected Unapproved]		Large Fab	Composite	_	Supplier		
Root	\neg				Desc	ription of work order update		nitial	Acti	ion	Sign &			
Cause	- 1	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector	
Design														
Doc/Data														
Equip/Tooling	Ш													
Handling/Pre	Ш													
Material	Ш													
Operator	Ш						Ì							
Offset/Setup										٠				
Process	Ш						1							
Supplier	Ш													
Training														
Transport ,			i				ĺ				ŀ			
Unapproved			<u> </u>		•				<u> </u>					
							FA	ULT CA	TEGORY					
Landi	ng G	Gear				General		3			~	_		
	-	Bending				Bend	<u></u>	- '	Program	·	Outside Dim	<u> </u>	Pressure/Forced	
	Ш	Centre No	ot Concer	ntric		BOM/Route	L	Grain		<u> </u>	Over/Under	<u> </u>	Set-up	
	-	Cracks Broken/Damage/Defec				Broken/Damage/Defect		Hardwa			Part Incorre	_	Temperature/Cure	
	Crimp/Kink/Ripple/Wave Burrs				Burrs	<u></u>	4 '	ion Incomplete/Un	· —	Part Lost/Mi	issing	Weld		
	Cuffs Contamination				-∤		4	tions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled		
	-	Crushing				Countersink						_		
	Ш	Heat Trea				Cut Too Short		Mislab		L.	Power Loss/	Surge	Other	
	\sqcup	Inspectio	-	Tube	lacksquare	Drawing		Misrea						
	\vdash	Marks/Cl			<u> </u>	Drill Holes		Off-set						
	Turning Sequence					Finish	Out of Calibration							
	Wave/Twist in Tube					Fit/Function	}	lout of	Sequence					

Picklist Print

November-12-13 3:19:35 PM

Work Order ID: 109165

109165

Parent Item:

D2933-1

D2933-1

Parent Item Name: 206 Saddle Left

Start Date: 11/12/13

Required Date: 11/26/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	44.0000	1	4			
D6101 00	11								**		1	S	

1)6101-001

Saddle Billet

Location	Loc Oty	Loc Code	
MAT042	44		-
108097	26		-i/
108272	16		
97239	2		

13-11-27.

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:						· · · · · · · · · · · · · · · · · · ·		Wo	ork Order up	odate only	
Work Orde	r:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
	•		······		_	Rework	1 		Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging	Other
NCR N	Ю.					Suspected Unapproved			Large Fab	Composite			Supplier	
Root		<u></u>			Desci	ription of work order update		nitial	Actio	on		Sign &	,	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification	QC Inspector
Design														
Doc/Data	_	· ·												ŀ
Equip/Tooling														
Handling/Pre	\vdash													
Material														
Operator														
Offset/Setup		l					1							
Process														
Supplier														
Training Transport										•				
Unapproved							ļ							
опаррточеа			<u>.l</u> i			<u>-</u>	FAI	ULT CA	TEGORY			<u> </u>		<u> </u>
Landi	ng (Gear				General							-	
	$\overline{}$	Bending				Bend	Г	Folio/f	Program	1		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ct	Temperature/Cure
:		Crimp/Kink/Ripple/Wave Burrs				Burrs		Inspect	ion Incomplete/Unc	qualified		Part Lost/M	issing	Weld
		Cuffs Contamination				Contamination		Instruc	tions Incomplete/Ur	nclear		Part Moved		Wrong Stock Pulled
		Crushing	·				Misali	gned/off center			Positioned \	Vrong		
		Heat Trea	at		Cut Too Short			Mislabeled Power			Power Loss/	Surge	Other	
		Inspection Strip in Tube Drawing						Misrea						
						Drill Holes		Off-set						
	Turning Sequence Finish						4	Calibration						
	Wave/Twist in Tube Fit/Function							Out of	Out of Sequence					

DART AEROSPACE LTD	Work Order:	109/65
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

	t		X First A	irst Article Prototype								
				Record Actual Dimensions								
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5				
Α	0.100	0.140		.112	-10-	-112	. 117					
В	0.100	0.140		. (04	109	.107	.108					
C	0.100	0.140		011.	-110	.109	.110					
D	0.210	0.230		1226	.224	· LLL	.225					
Е	1.245	1.255		1.250	(-230	1.250	1.250					
F	1.245	1.255		1.250	1.250	1.20	1.250					
G	2.495	2.505		2.500	3.500	2.500	2.500					
Н	0.510	0.515		.513	.513	1.513	513					
	1.572	1.582		1.577	1577	1.57+	1.577					
J	2.495	2.505		2,500	2.500	2.500	2.500					
K	0.257	0.262		.260	.)(0	1260	.260					
L	0.312	0.317		.3(5	. 75	1.315	.315					
M	0.235	0.240		.237	,237	.238	.23%					
N	0.100	0.140		121	1(19	114	1/0					
0	0.540	0.560		.546	1.544	1597	.546					
Р	0.490	0.510		.497	.498	3497	3.720					
Q	3.715	3.725		3.720	3.720	3.720						
R	2.470	2.510		2.490	2.490	2.490	2.490					
S	0.240	0.270		.255	()	1.61	.253					
T	0.100	0.180 1.635		.140	140	1.630	1.630					
V	1.625 1.362	1.835		(.63)	13(3)							
W	0.316	0.321		.318	3/8	1.367	1.367					
X	1.125	1.145		1.135	1/3/	318	1.136					
Ŷ	1.125	1.585		1.16	1.139	1.736	1.176					
Z	0.178	0.198		-186	1.2 17	.16%	188					
AA	0.176	0.130		- 1700	. (00	1100	, (0-6					
AB												
AC		+			 	 						
AD		1	· · · · · ·			<u> </u>		•				
AE						<u> </u>						
			Accept/Reject									
	Measure	d by:	020			Date:	13-1	1.28				
		d by: Cm	269			Date:						
Proto	otype Appr	oval:		N/A		Date:	4	I/A				
Rev	Date	Change					evised by	Approved				
A		New Issue				R	F					
В	02.12.12	DT8695 A/B	dded Dim. X-Y,		8686, DT869	90 % K	J/RF					
С	06.10.03	Removed DT	8683, DT8686	& DT8690		K	J/JLM					
D												
E	08.01.16	DT8695 A/B r	emoved from d	limension Y		K	J/EC/DD	18				

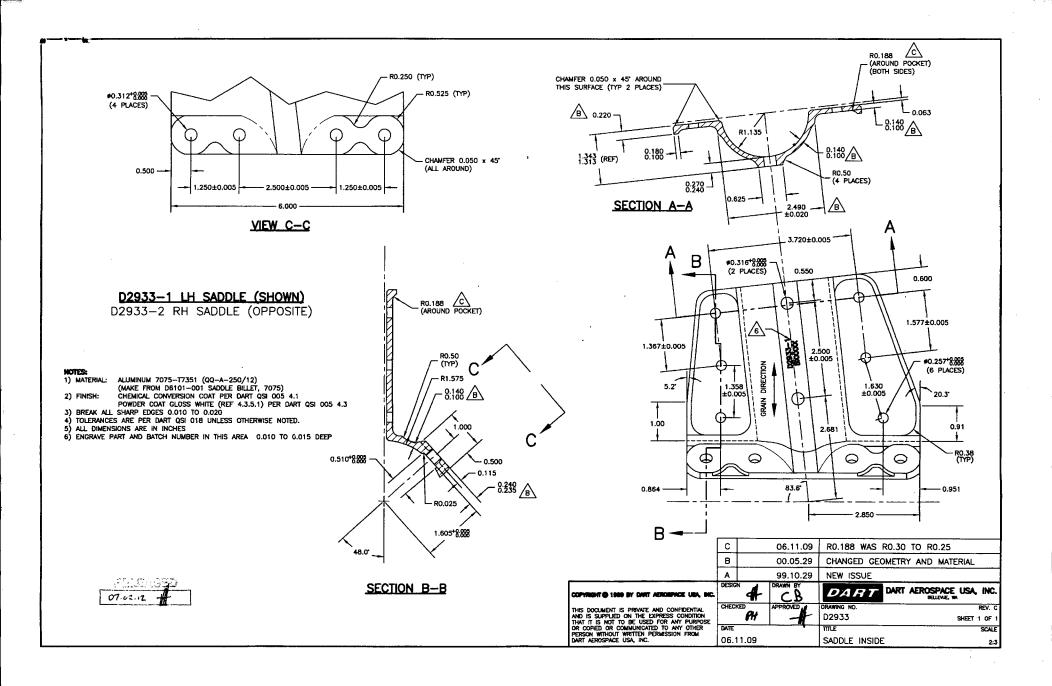
DQA:			Date:											
					WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
QA Closed:			Date:						·	W	ork Order up	odate only		
Work Orde	·r·					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
WOIR OIGC	-					Rework	1		Skid-tube Crosstube			Water Jet	Engineering	
Part N	lo.					Scrap	1		Machining Small Fab	-	Pro	d. Eng. Coor.	Quality	
	-				_	Use-as-is	1 1		noforming Finishing		1	re/Packaging	Other	
NCR N	lo.					Suspected Unapproved]		Large Fab Composite]	Supplier		
Root	Т				Desc	ription of work order update	Н	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng			Date	Verification	QC Inspector	
Design	7													
Doc/Data			:				1							
Equip/Tooling														
Handling/Pre														
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Training					1				·					
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Unapproved														
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Landi		ł				General	_	3 ,-	_		1	. —	7	
		Bending			<u> </u>	Bend	 	-	Program	ļ.	Outside Dim	·	Pressure/Forced	
		Centre N	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		\vdash	Over/Under	 	Set-up	
	_	Cracks			-	Broken/Damage/Defect	-	Hardwa I.		\vdash	Part Incorre	<u></u>	Temperature/Cure Weld	
	-	Crimp/Ki	nk/Ripple	e/Wave		Burrs	-	4 '	tion Incomplete/Unqualified	-	Part Lost/M	- h-	Wrong Stock Pulled	
1	_	Cuffs			-	Contamination	-	-4	tions Incomplete/Unclear		Part Moved	_		
		Crushing			-	Countersink	\vdash	-1	gned/off center	\vdash	Positioned \ Power Loss	_	Other	
	_	Heat Trea		T la . a	_	Cut Too Short	\vdash	Mislab Misrea		<u></u>	Jrower Loss/	Juige	Tottlei	
	\vdash	Inspectio		Tupe	\vdash	Drawing Drill Holos	\vdash	Off-set						
]	\vdash	Marks/Ch			\vdash	Drill Holes	\vdash	┥	: Calibration					
		Turning S	-		-	Finish	-	-						
l	ı	Wave/Tw	vist in Tul	be		Fit/Function	Į.	Out of	Sequence					

Location/Lot Activity

November-12-13 3:12:43 PM

Page 1 of 1

Criteria:	All Items	All Locations	Lot: 122139	All Transacti	on Types All Dat	es Report o	n Locations & Lo	ts			
Transaction Type	Item Item	ID/ Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	Lot Qty	Shelf Life Date	Extended Cost
Issue	AP0925ELBN / Bared Elbow		Main Warehouse ST283	86074	DESJ02	8/07/12	10.0000	122139	10.0000		-\$0.45
			Main Warehouse	86075	QUIR01		9.0000	12103	9.0000		ψ0.10
			ST283	027/0	DDIGO	9/24/12	-1.0000 6.0000	122139	-1.0000 6.0000		-\$0.45
			Main Warehouse	93769	BRIS01		0.0000				
			ST281			9/06/13	-1.0000 5.0000	122139	-1.0000 5.0000		-\$0.45
			Main Warehouse	93803	BRIS01		3.0000		3.0000		
			ST281			9/06/13	-1.0000	122139	-1.0000		-\$0.45
									-4.0000		-\$1.81
Loc Transfer	AP09 Elbov	0925ELBN / Bared ow	Main Warehouse		GOLD01		0.0000		0.0000		
			ST281			11/26/12	8.0000	122139	8.0000		\$3.62
			Main Warehouse		GOLD01		8.0000		8.0000		
			ST283			11/26/12	-8.0000	122139	-8.0000	-	-\$3.62
									0.0000		\$0.00
PO Receipt	AP09 Elboy	20925ELBN / Bared Dow	Main Warehouse ST283	PO17240	DESJ02		0.0000		0.0000		
	2.00					6/20/12	10.0000	122139	10.0000		\$4.53
									10.0000		\$4.53
Shipment	AP09 Elbov	025ELBN / Bared w	Main Warehouse	SO111603	CARR01		8.0000		8.0000		
			ST281	SO111603		5/17/13	-1.0000	122139	-1.0000		-\$0.45
			Main Warehouse		CARR01		7.0000		7.0000		
			ST281			5/17/13	-1.0000	122139	-1.0000	-	-\$0.45
					•				-2.0000		-\$0.91



DQA:			Date: _				TRAC							
O. C. J. Date:						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								
QA Closed:			Date:				_				VVC	ork Order up	date only	
Work Order:						DISPOSITION								
	•					Rework	1		Skid-tube	Crosstube		Water Jet Engineering		
Part No.						Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is		Thermoforming Finishing				Rec/Stor	e/Packaging	Other
NCR No.						Suspected Unapproved	ected Unapproved			Large Fab Composite				
											<u>, </u>			
Root					Desc	ription of work order update		nitial	Acti			Sign &		
Cause		Date	Step Qty or n			or non-conformance	ance Chi		Eng Description		Date		Verification	QC Inspector
Design														
Doc/Data							İ							
Equip/Tooling														
Handling/Pre			:											
Material							1							
Operator	Н					,								,
Offset/Setup							1							
Process		·					ď							
Supplier Training							ŀ							
Transport		Ì												
Unapproved	H													
	1	1		1	<u> </u>		FA	ULT CA	TEGORY			*		
Landi	ng (Gear				General						•••		
	Ť	Bending				Bend		Folio/Program				Outside Dim	ensions	Pressure/Forced
		Centre Not Concentric				BOM/Route		Grain				Over/Under	tolerance	Set-up
į		Cracks				Broken/Damage/Defect		Hardware				Part Incorre	cí	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ction Incomplete/Unqualified		L	Part Lost/Missing		Weld
	Cuffs					Contamination			tions Incomplete/Unclear			Part Moved		Wrong Stock Pulled
		Crushing				Countersink	Шмі		saligned/off center			Positioned V		
		Heat Treat				Cut Too Short	Mislat		<u> </u>			Power Loss/	Surge	Other
		Inspection Strip in Tube				Drawing		Misrea					<u></u>	·
	Marks/Chatter					Drill Holes	\vdash	Off-set						
	Turning Sequence				<u> </u>	Finish	_	-	Calibration					#***
	Wave/Twist in Tube					Fit/Function		Out of Sequence						